

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

- NOTES**
- 1) MATERIAL: N/A
 - 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: 12.5 lb
 - 9) WELD PER DART QSI 004
 - 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
 - 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
 - 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

DEO ATTACHED

RELEASED

CP 09.03.03

per ECN 09-532

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE USA, INC	
DRAWN	92	PORT HADLOCK, WA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 1 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	140	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

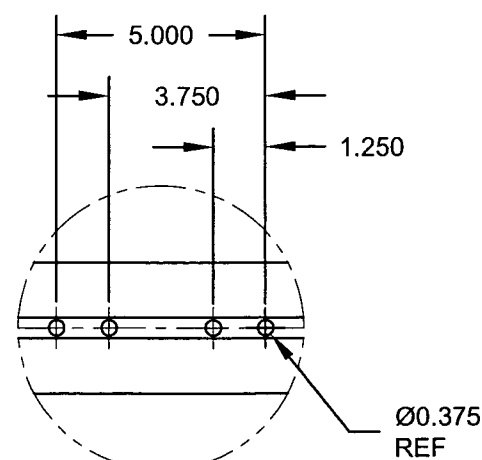
DEO ATTACHED



DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	JB	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 3 OF 5
APPROVED	160	TITLE	SCALE
DE APPR.	111	SKIDTUBE ASSEMBLY, 206A/B	NTS
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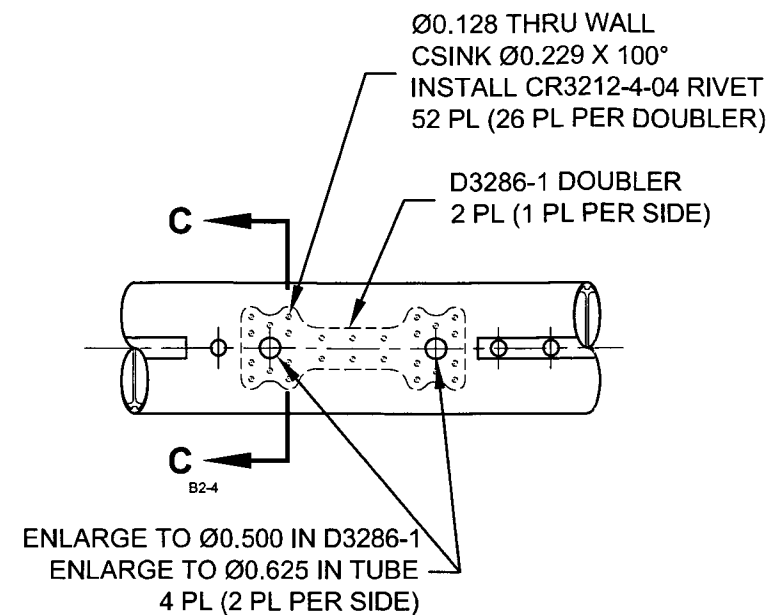
RELEASED
CP 09.03.03

DEO ATTACHED



DETAIL A
SCALE NONE

D6-2
C2-2
D6-3
C2-3



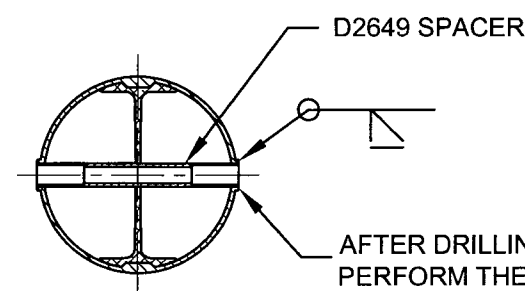
DETAIL B
SCALE NONE

C3-2
C3-3

- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE

C6-4



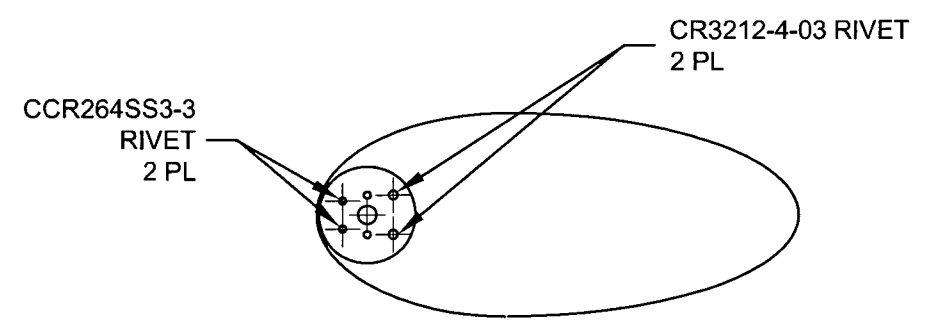
SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE

A4-2
A4-3

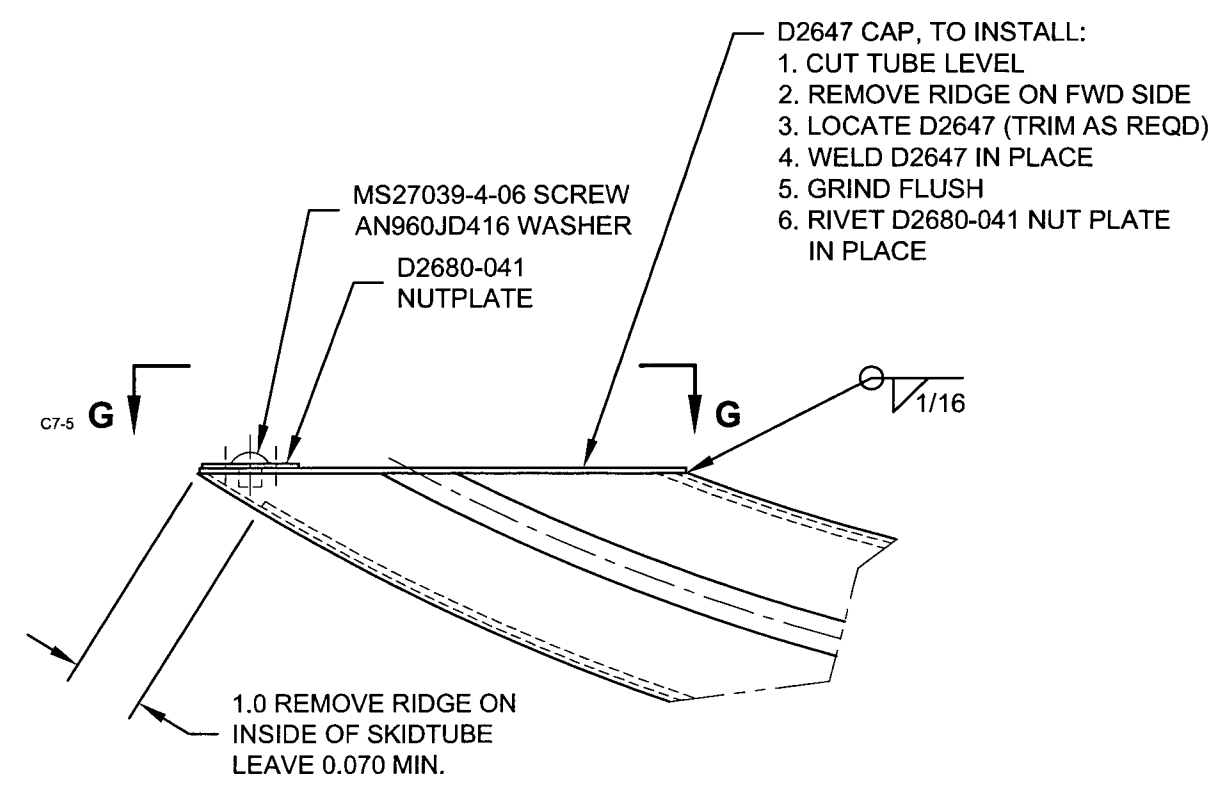
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 4 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	14	SKIDTUBE ASSEMBLY, 206A/B	NTS
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09.03.03

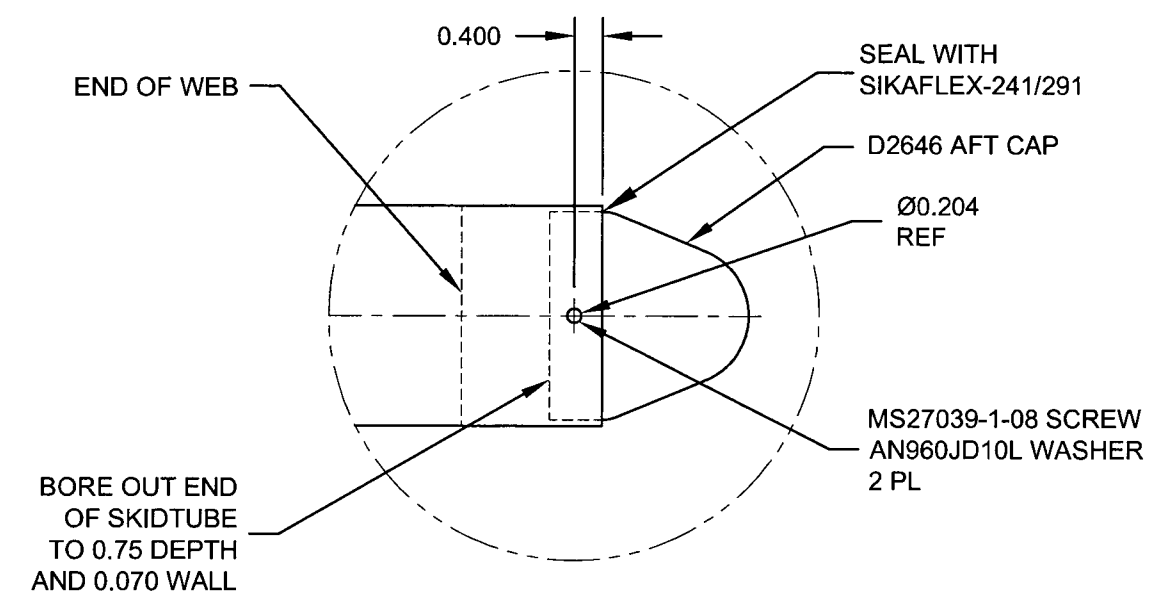
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VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2
B7-3



DETAIL F
SCALE NONE B2-2
B2-3

DESIGN	92	DART AEROSPACE USA, INC	
DRAWN	JA	PORT HADLOCK, WA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 5 OF 5
APPROVED	92	TITLE	SCALE
DE APPR.	JA	SKIDTUBE ASSEMBLY, 206A/B	NTS
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DRAWING NO. D3804	TITLE SKIDTUBE ASSEMBLIES, 206A/B	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3804-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>AP.</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

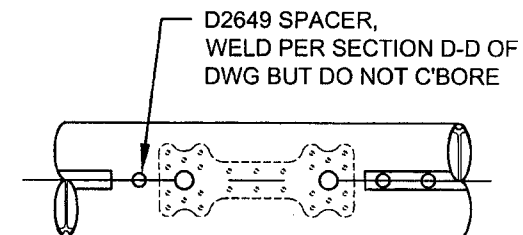
IS:

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	1	D2649	CROSS BOLT SPACER
18	19	D4720-1	SPACER

WAS:

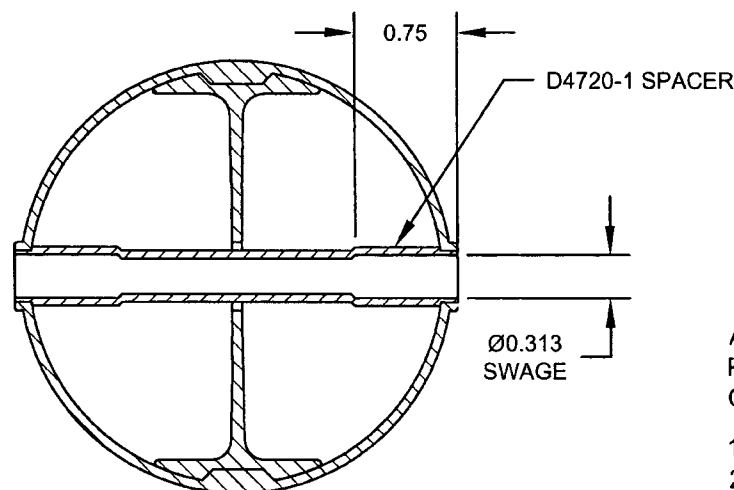
19	20	D2649	CROSS BOLT SPACER
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ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG.
C'BORED HOLES ARE **NOW SWAGED** PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE



SECTION H-H

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY

NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

RELEASE
2012-11-16
[Signature]